Date: Wednesday, 3/7/2007 3:46:35 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 31057		
Estimate Number	: 10022		
P.O. Number	: N/A	Part Number	: D205634011
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 31056	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.07		
Comment	: Est Rev: 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D205-634-011 CHG004 CL KJ 07.03.12 ①

Seq. #:	Machine Or Operation:	Description :
2.0	31057A	SKID TUBE ASSEMBLY

Comment: Sub-Component SKID TUBE ASSEMBLY
D205-634-041 B 31057A 7/4/18 SQ

Seq. #:	Machine Or Operation:	Description :
3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
4.0	K10003	D205-634-011 Saddle Kit

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	B30779
1	D205-634-041	Skidtube Assembly(ref)	B31057A

7/4/18 SQ

Seq. #:	Machine Or Operation:	Description :
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

CL 07/04/18 ①

Comment: INSPECT 100% KITS FOR COMPLETENESS 7/4/18

 Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Wednesday, 3/7/2007 3:47:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 31057A			
Estimate Number	: 10023			
P.O. Number	: N/A		Part Number	: D205634041
This Issue	: 3/7/2007	S.O. No. : N/A	Drawing Number	: D2580 REV C
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A	Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 31056A		Material	: N/A
Written By	:		Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.07			
Comment	: Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC			

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001 N/A.

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch	
1	D2500-1-190	Skid Tube Extrusion	B 29602	JD 7-3-19

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch	
1	D2596	205 Web	B 31110	JD 7-3-20

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends — JD 7-3-19

3-Acid etch and Alodine tube per QSI 005 4.1

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid) — JD 7-3-20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31057A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

JD 7-3-20

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	m 103497	

JD 7-3-20

Sikaflex expire date: 7-10-1
Start Time: 3:00 Date: 7-3-20
Fin Time: 3:00 Date: 7-3-28

5.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE
1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580 EL 7-3-28

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes Pw 07-04-03 (1)

7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP DP 7-4-2

8.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B29486 BE 07-04-02

9.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31057A

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
20	D2579	Spacers B 30220 BE 07-04-02
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 07-04-02

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod M103317 BE 07-04-02

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod M103317 BE 07-04-02

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending PM 07-04-03 (1)

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr PM 07-04-03 (1)

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes PM 07-04-03 (1)

7-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Deburr PM 07-04-03 (1)

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr PM 07-04-03 (1)

11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/04/03 (1)

12.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/04/03 (1)

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005 07-04-10 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 3/7/2007 3:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31057A

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	POWDER COATING	POWDER COATING

m101706

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 FR 07/04/10 (1)

Seq. #:	Machine Or Operation:	Description :
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7/4/11 (1)

Seq. #:	Machine Or Operation:	Description :
16.0	D25771	Wearplate Fwd

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B29994

Seq. #:	Machine Or Operation:	Description :
17.0	D25773	Wearplate Aft

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B29960

Seq. #:	Machine Or Operation:	Description :
18.0	D25775	Wearplate, Centre

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B31254

Seq. #:	Machine Or Operation:	Description :
19.0	ALS71032130	Insert

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	M103495

07-04-11 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31057A

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD10L	Washer

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4 4	AN960JD10L	Washer	M102832

Seq. #:	Machine Or Operation:	Description :
21.0	AN34A	Bolt

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	M100857

Seq. #:	Machine Or Operation:	Description :
22.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B30140

Seq. #:	Machine Or Operation:	Description :
23.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

Seq. #:	Machine Or Operation:	Description :
24.0	D2855	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B27488

Seq. #:	Machine Or Operation:	Description :
25.0	AN35A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15205

KJ 07.04.11 (1)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/04/17

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 31057A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
26.0	AN960JD10L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M102832 07-04-11

27.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M103497
Sikaflex expire date: 07/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 M103497
Sikaflex expire date: 07/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: M103707 07/04/16

07-04-11

28.0	QC5	INSPECT WORK TO CURRENT STEP

07-04-16

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location: PPD 31057
PPP Rev: 7/4/18

30.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/04/

Job Completion 07.04.18

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. C — SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY — SCALE NTS

DART

QA COPY ISSUED

RELEASED 98/09/17 DS

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

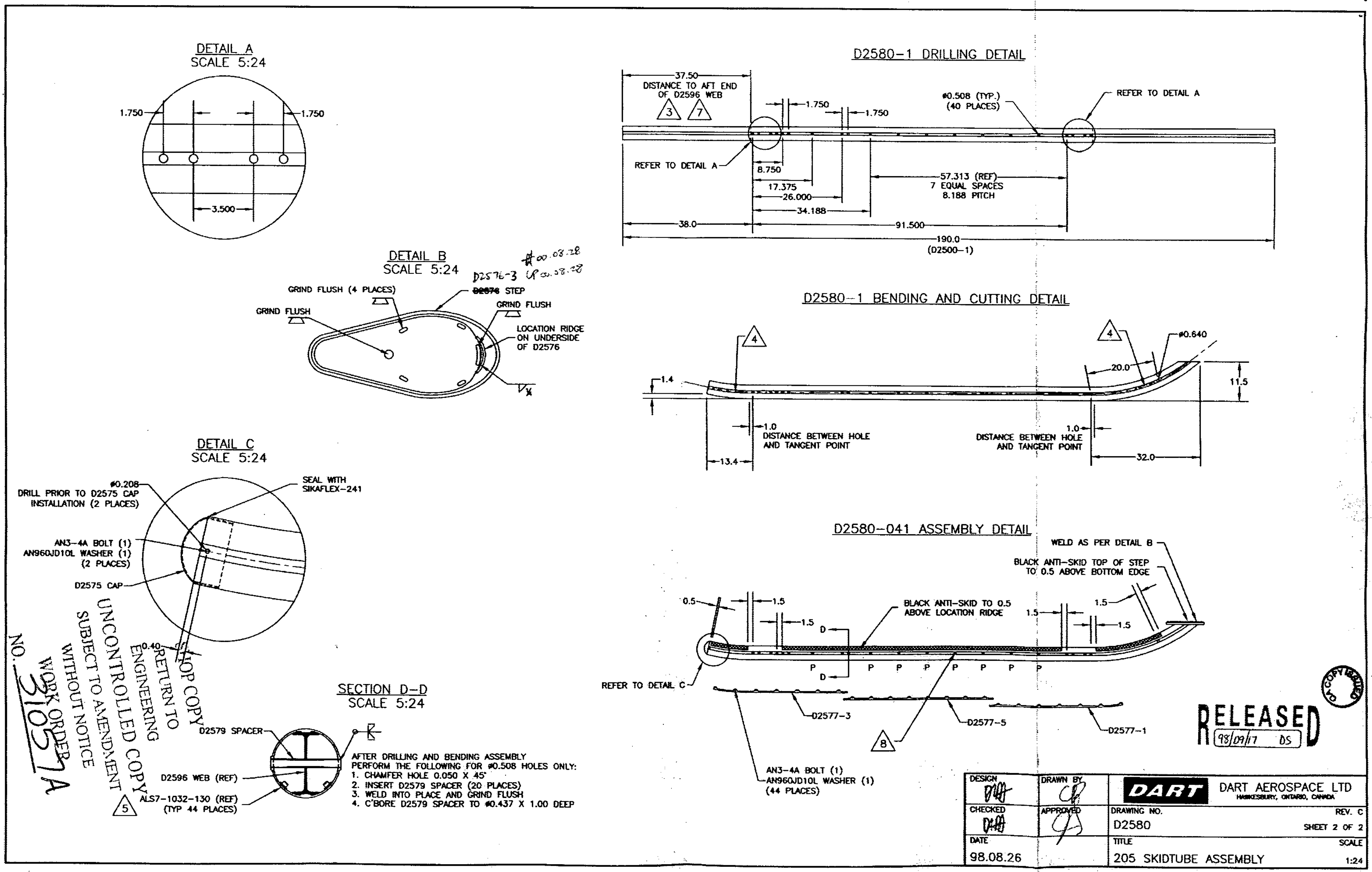
00.08.28
00.08.28

EFFECTIVE DEOs
DEO 9124 98/12/14
DEO 9183 00.08.28

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
   POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO 31057A


DETAIL A
SCALE 5:24
1.750
1.750
3.500
D2580-1 DRILLING DETAIL
37.50
DISTANCE TO AFT END OF D2596 WEB
3
7
1.750
1.750
ø0.508 (TYP.) (40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF) 7 EQUAL SPACES 8.188 PITCH
38.0
91.500
190.0 (D2500-1)
DETAIL B
SCALE 5:24
GRIND FLUSH (4 PLACES)
GRIND FLUSH
D2576-3 STEP
GRIND FLUSH
LOCATION RIDGE ON UNDERSIDE OF D2576
D2580-1 BENDING AND CUTTING DETAIL
4
4
ø0.640
20.0
11.5
1.4
1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT
1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT
13.4
32.0
DETAIL C
SCALE 5:24
ø0.208 DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
SEAL WITH SIKAFLEX-241
AN3-4A BOLT (1) AN960JD10L WASHER (1) (2 PLACES)
D2575 CAP
0.40
D2580-041 ASSEMBLY DETAIL
WELD AS PER DETAIL B
BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
0.5
1.5
1.5
BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
1.5
1.5
1.5
D
D
P P P P P P P P
REFER TO DETAIL C
D2577-3
D2577-5
D2577-1
8
AN3-4A BOLT (1) AN960JD10L WASHER (1) (44 PLACES)
SECTION D-D
SCALE 5:24
D2579 SPACER
D2596 WEB (REF)
5
ALS7-1032-130 (REF) (TYP 44 PLACES)
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP
TOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 3105 7A
RELEASED 98/09/17 DS
QA COPY ISSUED
DESIGN
DRAWN BY
CHECKED
APPROVED
DATE 98.08.26
DART
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2580
REV. C
SHEET 2 OF 2
TITLE 205 SKIDTUBE ASSEMBLY
SCALE 1:24

NO: 101

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D205634041 / B31181A

TEST WELDS REQUIRED

BASE METAL Alum **WELDING PROCESS** Tig
Penetration Complete [ ] Partial [✓] **Single Weld** [✓] **Double Weld** [ ]
Current AC [✓] DC [ ] **Backing** YES [ ] NO [✓]

	Position		**Vertical** Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ____________ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/29 **Qualifier** David Anwal

Dart Aerospace Ltd.

Date: Friday, 09/02/2007 9:59:35 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D205-635 / D204-635
Job Number	: 30722		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: ~~Z-CUSTOM~~ ECN953/908
This Issue	: 09/02/2007 **S.O. No.** : N/A	**Drawing Number**	: UPDATE PAPERWORK
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : OVERHEAD	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 16/02/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563NY

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

Voir papier avec ✓

7/4/27 SP

2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
RETURN TO STOCK

7/4/23 SP

Form: rprocess